

# Work Order ID 93539

Monday, November 19, 2012 4:22:18 PM

**\*93539\***

Page 1

Item ID: D412-711-101

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Bubble Window

Start Date: 11/19/2012 Start Qty: 200

**\*2\***

Cust Item ID:

Required Date: 11/23/2012 Req'd Qty: 200

**\*2\***

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 12-11-19

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D412-711-101

A

100

0.00

**\*100\***

DC

Document Control

Memo

Photocopy bluefiles and create labels  
for PPP D412-711-101 Change 002

0.00

*DAS 15 12/11/20*

*ML5 12-11-27*  
*(2)*

110

0.00

**\*110\***

HandThermo

HAND FINISHING THERMOFORMING

Memo

Set up Machine as per folio FTA 077 and D711W program using mould DT9640

0.00

Hand Finishing Thermoforming

*1*

*B 12/11/20*

120

0.00

**\*120\***

HandThermo

HAND FINISHING THERMOFORMING

Memo

Cut Blanks to 37.5" by 43"

0.00

Hand Finishing Thermoforming

*x1*

*B 12/11/20*

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Page 2

Item ID: D412-711-101

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Bubble Window

Start Date: 11/19/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 11/23/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

130

0.00

**\*130\***

Thermoform

THERMOFORMING MACHINE

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D412-711-101 using DT 9640 and Folio FTA

077

Dwg. Rev. A

Folio Rev. X

Visually inspect for proper formation and clarity

160

0.00

**\*160\***

HandThermo

HAND FINISHING THERMOFORMING

Memo

0.00

Hand Finishing Thermoforming

1) Trim off excess flange material 2) Buff out any light scratches or  
blemishes 3) Etch part number and batch number

170

0.00

**\*170\***

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

1) Visually inspect for clarity, and proper formation.

XI B 12/11/20

1 B 12/11/22

1 B 12/11/22

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Item ID: D412-711-101

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Replacement Bubble Window

Start Date: 11/19/2012 Start Qty: 2.00 \*2\*

Cust Item ID:

Required Date: 11/23/2012 Req'd Qty: 2.00 \*2\*

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start \*NR1\*

QC: Date:

SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
*180*									
QC	Memo	0.00							
Quality Control	1) Visually inspect for clarity, and proper formation.								
185	QC4- 100% Inspect kits for completeness	0.00							
*185*									
QC	Memo	0.00							
Quality Control									
190	Identify as per dwg & Stock Location: <u>020</u>	0.00							
*190*									
Packaging	Memo	0.00							
Packaging									

DAS  
16  
2-83  
12/11/23

S  
16  
2-83  
12/11/27

Q

12/11/27 DAS  
20  
2-83

**Work Order ID 93539**

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**\*93539\***

Page 4

Item ID: D412-711-101

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Bubble Window

Start Date: 11/19/2012 Start Qty: 2.00 **\*2\***

Cust Item ID:

Required Date: 11/23/2012 Req'd Qty: 2.00 **\*2\***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start **\*NR1\***

QC: Date:

SPC (Y/N): Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

QC21- Final Inspection - Work Order Release

0.00

**\*200\***

QC

Memo

0.00

Quality Control

12/11/28  
ME  
12-11-28

# Picklist Print

Monday, November 19, 2012 4:22:17 PM

Page 1

Work Order ID: 93539

Parent Item: D412-711-101

Start Date: 11/19/2012

Required Date: 11/23/2012

Parent Item Name: Replacement Bubble Window

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-02-01 JLM  
10/06/28 DL

IPP Rev. B. Manufacture in-house

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.236 Plexiglass G .236"		Purchased	No				sf	325.2755		42.666667			

Location

Loc Qty

Loc Code

therm

325.2754524

119347

0.803174

120972

0.00227844

122537

132.47

122582

192

(DAS)  
07  
12-89

12/11/23

21.3359 PL

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 98539
<b>Description:</b> Replacement Window		<b>Part Number:</b> D412-711-101
<b>Inspection Dwg:</b> D412-711-101	<b>Rev:</b> A	<b>Page 1 of 1</b>

**FIRST ARTICLE INSPECTION CHECKLIST**  
**THERMOFORMING SECTION**

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

**Measured by:** JP

**Date:** 12/11/22

**TRIMMING SECTION**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	+/-0.030	2.16	✓		DL-01	
1.73	+/-0.030	1.87	✓		DL-01	
1.98	+/-0.030	2.04	✓		DL-01	
1.50	Min	1.51	✓		DL-01	
0.090	Min	.098	✓		ULTRASOUND	
0.070	Min	.092	✓		" "	
0.050	Min	.082	✓		" "	
15.0	+/-0.5	15.06	✓		TH-05	

**Measured by:** JP

**Date:** 12/11/22

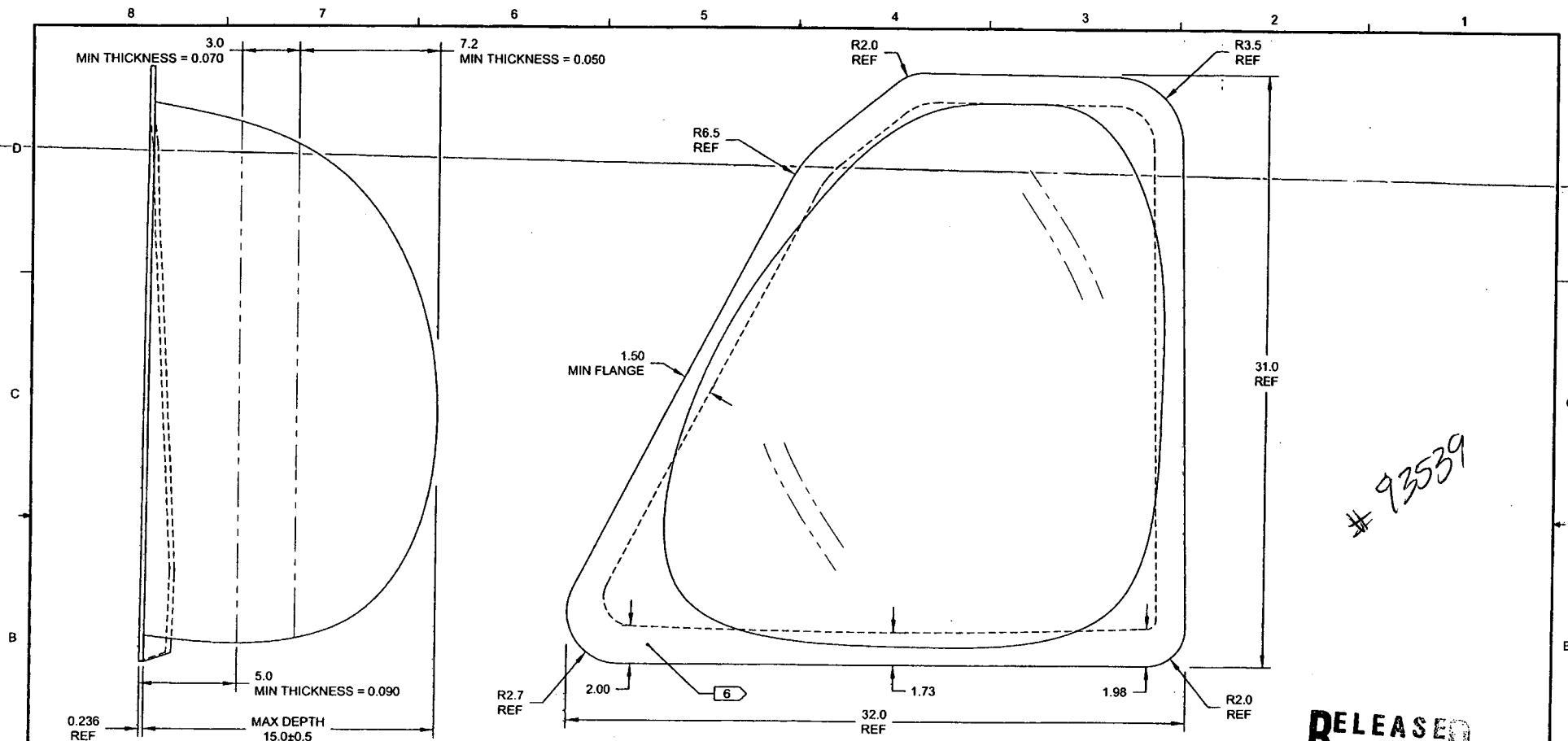
**Audited by:** DAS 16 12/11/23

**Date:**

**Preliminary Approval:**

**Date:**

Rev	Date	Change	Revised by	Approved
B	10.10.08	New Issue	KJ	



### D412-711-101 REPLACEMENT WINDOW

#### NOTES:

- 1) MATERIAL: PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C  
OR POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425,  
0.236 THICK (STOCK, REF. DART SPEC. M-ACRYLIC-S.236)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N "D412-711-101" & B/N "BXXXXX" ON THE INSIDE SURFACE  
OF THE BUBBLE WINDOW FLANGE, WITHIN 0.25" OF BUBBLE. USE 0.125" LETTERS TO MAX. DEPTH OF 0.005"
- 7) WEIGHT: 8.0 lbs
- 8) VACUUM FORMING: PER FOLIO FTA077 USING DT9640 MOLD AND DART QSI 022

A		NEW ISSUE		MB		10.06.28	
REV.		DESCRIPTION		BY		DATE	
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				REV. A	
DRAWN						SHEET 1 OF 1	
CHECKED		DRAWING NO.				SCALE	
MFG. APPR.		D412-711-101				NTS	
APPROVED		TITLE					
DE APPR.		REPLACEMENT WINDOW					
DATE		10.06.28					

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